



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3537-1
Job Sheet 169425



Part No: D3537-1

Job Qty: 30 ea

Part Name: Wearpad



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/11/17

Job Tracking No:

Due Date: 12/22/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-02-14 JLM IPP REV:B 15.10.16 added automated welding DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		12/21/17	0.00	0.00	Start Up Waterjet		OK 17/12/13
105	Waterjet	30 pcs		12/21/17	0.00	1.29	Waterjet1		OK 17/12/13
125	QC	30 pcs		12/21/17	0.00	0.00	QC8		OK 17/12/13 JMS 38
140	Brake NC	30 pcs		12/21/17	0.03	0.39	Brake NC 1		SI 389
150	QC	30 pcs		12/21/17	0.00	0.00	QC5		PD 17.12.13
160	Autoweld 1	30 pcs		12/22/17	0.00	2.22	Automated welding		EL
170	QC	30 pcs		12/22/17	0.00	0.00	QC10		PD
180	QC	30 pcs		12/22/17	0.00	0.00	QC5		PD
210	Packaging	30 pcs		12/22/17	0.00	0.00	Packaging3-1		BEB 17/12/20
220	QC21-SA	30 Ea		12/22/17	0.00	0.00	QC21		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S16GA	3	62	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	4.250inches $\pm$ 0.010	4.260 4.240		
2	Wearpad	3.500inches $\pm$ 0.010	3.510 3.490		
3	Wearpad	1.970inches $\pm$ 0.030	2.000 1.940		
4	Wearpad	3.630inches $\pm$ 0.030	3.660 3.600		
5	Wearpad	2.420inches $\pm$ 0.010	2.430 2.410		
6	Wearpad	0.220inches $\pm$ 0.010	0.230 0.210		
7	Wearpad	0.375inches $\pm$ 0.010	0.385 0.365		
8	Wearpad	0.063inches $\pm$ 0.010	0.073 0.053		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS The ☐ Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com				
Description Work Order Deviation						
Root Cause <table style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%;"> <tr> <td style="width: 50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 50%;"> Tem ☐ Set-i ☐ BON ☐ Brok ☐ Insp ☐ Con ☐ Cou ☐ Cut ☐ Inst ☐ Drill ☐ </td> </tr> </table>	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Tem ☐ Set-i ☐ BON ☐ Brok ☐ Insp ☐ Con ☐ Cou ☐ Cut ☐ Inst ☐ Drill ☐
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OTHER : _____		Wearpad S021206				

Mfg Date: 12/13/17
 Job No: 169425

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Start up Operation

PART NO:
 Revision:
 Operation:
 Change No:

IB (QSI042) Approval

Completed By

ad hand / Supervisor
approval Verification

IC / QA Coordinator
Approval

Positioned Wrong
 Outside Dimensions
 Over/Under tolerance
 Part Incorrect
 Part Lost/Missing
 Part Moved
 Drawing
 Finish
 Misread
 Turning Sequence

